

Work Order ID 59668

Wednesday, June 09, 2010 12:33:28 PM

Page 1

Item ID: D3688-1

Accept

Revision ID:

Item Name: STUD

Start Date: 6/9/2010 Start Qty: 6.00

Required Date: 7/2/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3688

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DO NOT USE CHOP SAW

☐ Cut blank 11.673" long

SL 10/06/23

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA718 Rev: N/A & Dwg D3688 Rev: C ☐ 2-Deburr

3-Check .625" bore with DT9530 GO/NO GO Gauge

SL 10/06/23 (6)

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/06/23

(PTO)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-07-05	W/O Dwg Header	dwg is now @ Rev C. update exp. perm change	<i>[Signature]</i>	10.07.06		<i>[Signature]</i> 1007-05	<i>[Signature]</i> 10-07-05	
10-07-05	130 ↓ 160	additional & repeated steps remove from F.P.P. perm change	<i>[Signature]</i>	10.07.06		<i>[Signature]</i> 1007-05	<i>[Signature]</i> 10-07-05	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59668

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Page 2

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Lathe Conv

Conventional Lathe

~~CONVENTIONAL LATHE~~

Memo

Face to finished length as per dwg D3688 AND center drill as per Dwg D3688

0.00

0.00

140



QC

Quality Control

~~QC2- Inspect parts off machine FA1/FA1B~~

Memo

0.00

0.00

150



Doosan

Doosan Lathe

~~DOOSAN LATHE~~

Memo

1- Turn as per Folio FA718 Rev: _____ & Dwg D3688 Rev: _____ □2-Deburr per dwg D3688

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 59668

Wednesday, June 09, 2010 12:33:28 PM

Page 3

Item ID: D3688-1

Accept

Setup Start

Revision ID:

Item Name: STUD

Stop

Start Date: 6/9/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC2- Inspect parts off machine FA/PA/B Memo	0.00 0.00							
170  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	0		
180  Purchasing Purchasing	PURCHASING Memo Issue P/O: <u>12200</u> 2 <input type="checkbox"/> Certificate of conformaty is required	0.00 0.00							

BP 10/06/28

CZ 10/7/11 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Start Date: 6/9/2010 Start Qty: 6.00

Required Date: 7/2/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Rec'd 7/5/10 (6)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 10 07 05 (6)

210

Identify as per dwg & Stock Location: *670*

0.00



Packaging

Memo

0.00

Packaging

Rec'd 7/5/10 (6)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL 10/7/05

10-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 12:33:32 PM

Page 1

Work Order ID: 59668



Parent Item: D3688-1



Parent Item Name: STUD

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A New Issue 08-01-29 JLM Veriified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty	per Kit	Total	Qty	Date	Status
M174PH-H900R1.000		Purchased	No			100	f	63.1000		1.087	6.865263			
17-4SS H900 ROUND BAR 1.00														

Location

Loc Qty

Loc Code

MAT030

63.1

112374

1.5

112570

61.6

5.9

SL 10/6/23

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59668
Description: Stud		Part Number:	D3688-1
Inspection Dwg: D3688	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.695	✓			
0.625	+0.004/-0.000	.627	✓			
1.25	+0.000/-0.03	1.230	✓			
118°	0.5°	118°	✓			
R0.03	+/-0.030	.030	✓			
0.11 Ref	+/-0.030	.11	✓			
90°	0.5°	90°	✓			
Ø0.189	+0.005/-0.001	.191	✓			
1.31	+/-0.030	1.300	✓			
1.65	+/-0.030	1.650	✓			
0.870	+0.000/-0.010	.865	✓			
Ø0.659	+0.000/-0.015	.647	✓			
11.573	+/-0.015	11.575	✓			
2.90	+/-0.030	2.905	✓			
3/4-16UNF-2A	N/A	✓	✓			
0.075 x 45°	+/-0.010 x 0.5°	.08 x 45°	✓			
0.370	+0.000/-0.010	.365	✓			
Ø0.189	+0.005/-0.001	.191	✓			
R0.25	+/-0.030	.25	✓			
R0.50	+/-0.030	.50	✓			

Measured by:	Y
Date:	10/06/26

Audited by:	BP
Date:	10/06/28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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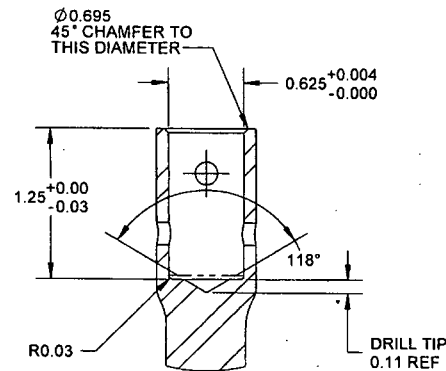
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

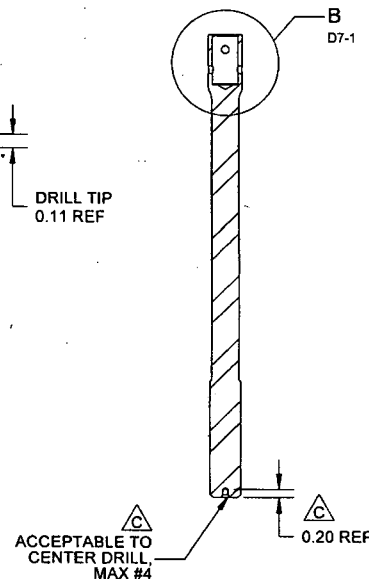
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WITHOUT NOTICE
WORK ORDER

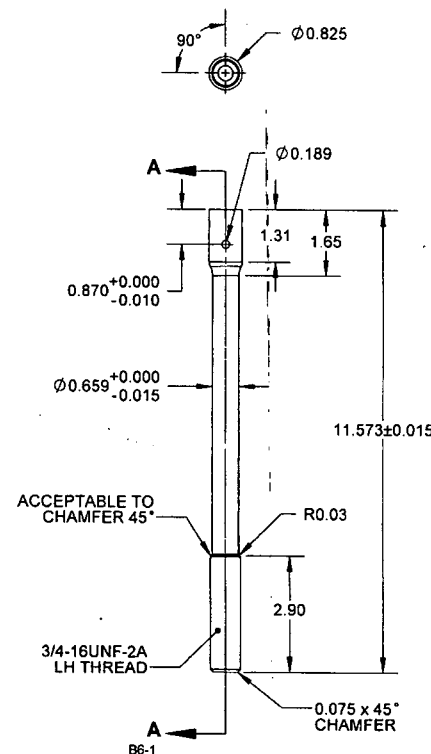
NO. 59068
3810-6-09



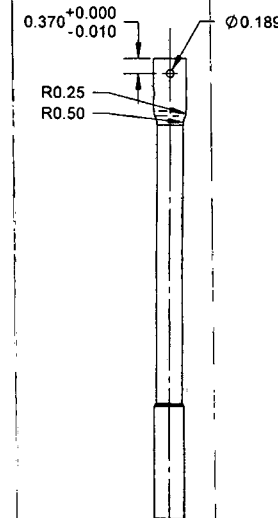
DETAIL B
SCALE 3X
D6-1



SECTION A-A
D4-1



D3688-1 STUD



RELEASED
2009-09-22

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.24 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B6-3, B6-4); UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REDUCE LENGTH ON D3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTOTYPE INSTALL; 0.695 WAS 0.665 (ZN D8-1, D8-2, D8-3); 0.508 WAS 0.475 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	40		
MFG. APPR.	21		
APPROVED	40		
DE APPR.	40		
DATE	09.09.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3688
REV. C
SHEET 1 OF 4
TITLE STUD
SCALE NTS

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

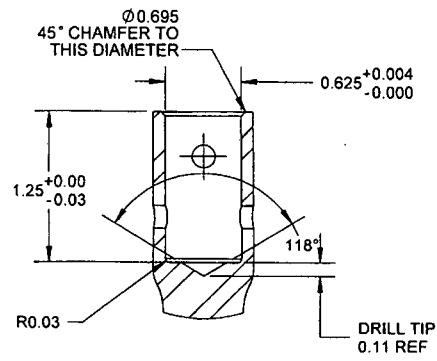
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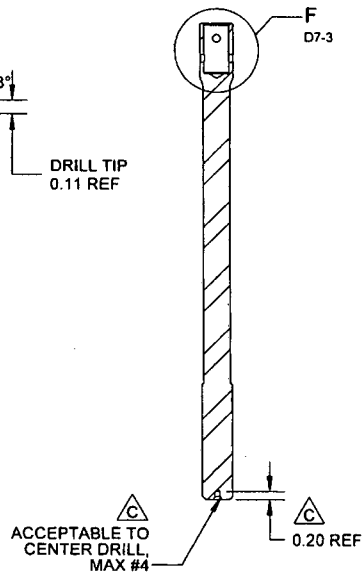
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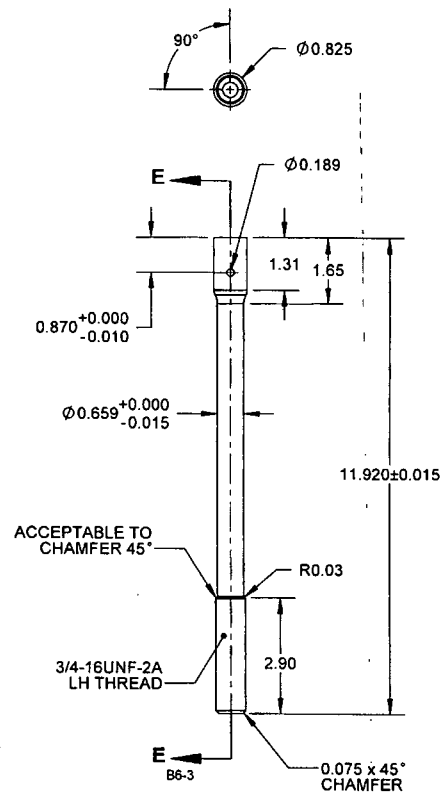
NOTE: Date & initial all entries



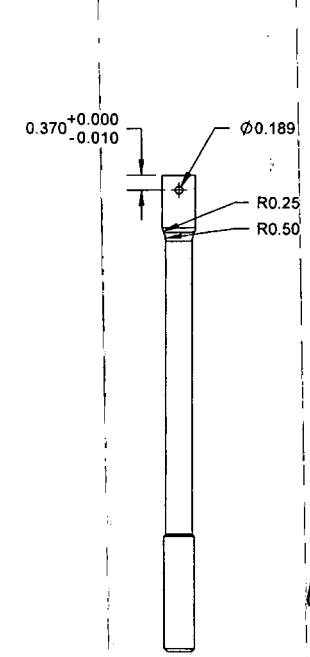
DETAIL F
SCALE 3X
D6-3



SECTION E-E
D4-3



D3688-5 STUD



1039668

RELEASED
2009-00-22

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.26 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D3688	SHEET 3 OF 4
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	STUD	NTS
DATE	09.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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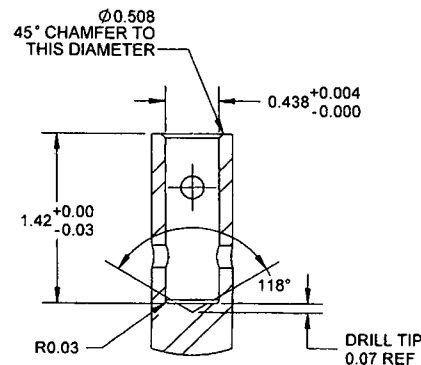
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

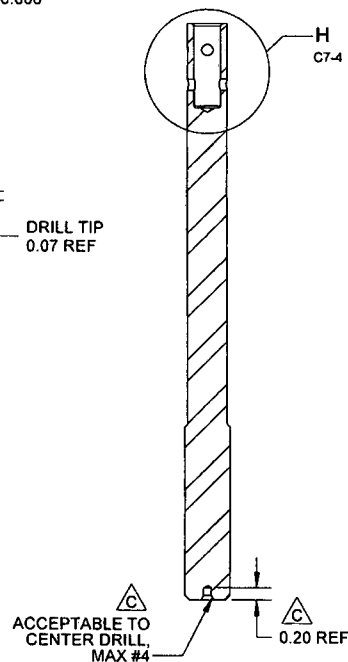
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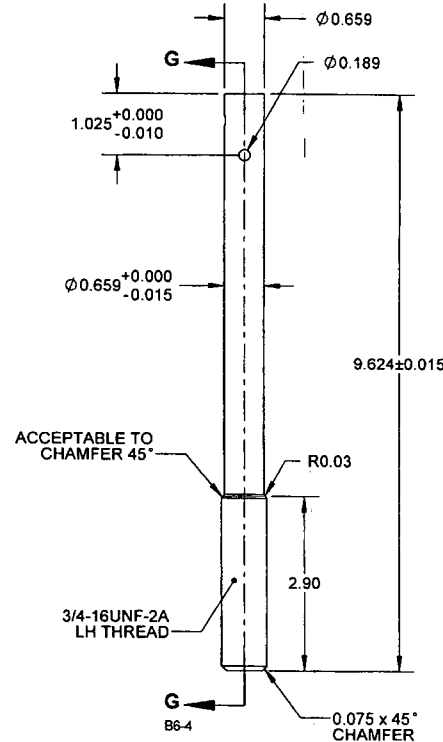
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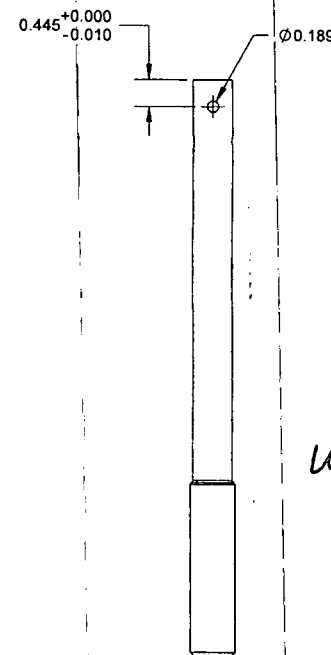
DETAIL H
SCALE 2X
D6-4



SECTION G-G
D4-4



D3688-7 STUD



w/o 59668

RELEASED
2009-09-22

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.97 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>GP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>GP</i>	D3688	SHEET 4 OF 4
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	STUD	NTS
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15329

PAGE 1 OF 1

CLIENT DACT AEROSPACE DATE JULY 2-2010 TIME AM ☒ PM ☐
ATTENTION LINDA CHANTEL ACUREN JOB NO. 188-10-0776
ADDRESS 270 ABERDEEN ST. PO/WO NO. 1122001
HAWKESBURY, ON. WORK LOCATION MAIN SHOP - HAWKESBURY
K&H 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON CROSS TUBES & MACHINED PARTS
ITEM(S) EXAMINED Four CROSS TUBES
ELEVEN MACHINED STUDS.

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-2 REV./DATE
PART NO. MATERIAL S. STEEL THICKNESS ALUMINE -
SCOPE WET FLOUORESCENT LIQUID PENETRANT ALUMINUM
INSPECTION CARRIED OUT 100% EXTERNAL.

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 450 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE OCT. 19
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY 2010

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☐ IMPERIAL

6 - STUDS - W.O. 59668 ✓
5 - STUDS - W.O. 58635 ✓
1 - CROSS TUBE - W.O. 59975 ✓
1 - CROSS TUBE - W.O. 59976 ✓
1 - CROSS TUBE - W.O. 58387 ✓
1 - CROSS TUBE - W.O. 58388 ✓
INDICATIONS ON CROSS TUBES.
W.O. # 59975
W.O. # 59976
W.O. # 58388
IN PROCESS TO BE REMOVED
10 07 05

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Bason Herdich PRINT SIGNATURE [Signature] DTR # E63366
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME (PRINT): MIKE J. HUSTON 1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL IV SNT LEVEL _____ CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 6606 CGSB REG. NO. _____

WHITE - CLIENT COPY CANARY - OFFICE COPY PINK - TECHNICIAN COPY GOLD - OFFICE COPY